



US007594321B2

(12) **United States Patent**  
**Dory et al.**

(10) **Patent No.:** **US 7,594,321 B2**  
(45) **Date of Patent:** **Sep. 29, 2009**

(54) **SUBSTRATE-IMPRINTING METHODS**

(75) Inventors: **Thomas S. Dory**, Gilbert, AZ (US);  
**Michael Walk**, Mesa, AZ (US)

(73) Assignee: **Intel Corporation**, Santa Clara, CA (US)

(\* ) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

(21) Appl. No.: **11/853,856**

(22) Filed: **Sep. 12, 2007**

(65) **Prior Publication Data**

US 2008/0000674 A1 Jan. 3, 2008

**Related U.S. Application Data**

(62) Division of application No. 10/322,902, filed on Dec. 18, 2002, now Pat. No. 7,371,975.

(51) **Int. Cl.**  
**H01K 3/10** (2006.01)  
**H05K 3/10** (2006.01)

(52) **U.S. Cl.** ..... **29/852; 29/830; 29/832; 29/846**

(58) **Field of Classification Search** ..... **29/825, 29/830, 846, 852, 832**  
See application file for complete search history.

(56) **References Cited**

**U.S. PATENT DOCUMENTS**

2,912,748 A 11/1959 Eric  
2,986,804 A \* 6/1961 Greenman et al. .... 29/852  
3,438,127 A 4/1969 Lethonen  
3,628,243 A 12/1971 Phol et al.  
4,049,903 A \* 9/1977 Kobler ..... 174/253

4,356,627 A 11/1982 Hoffman  
4,584,767 A \* 4/1986 Gregory ..... 29/848  
4,651,417 A 3/1987 Schumacher, III et al.  
4,704,791 A \* 11/1987 Chellis et al. .... 29/852  
4,912,844 A 4/1990 Parker  
4,941,255 A \* 7/1990 Bull ..... 29/833  
5,043,184 A 8/1991 Fujii et al.  
5,048,178 A \* 9/1991 Bindra et al. .... 29/830  
5,091,339 A 2/1992 Carey  
5,259,110 A 11/1993 Brass  
5,528,001 A 6/1996 Roberts

(Continued)

**FOREIGN PATENT DOCUMENTS**

CN 1279251 1/2001

(Continued)

**OTHER PUBLICATIONS**

“U.S. Appl. No. 10/323,165 Response filed Jan. 7, 2009 to Non-Final Office Action mailed Oct. 7, 2008”, 11 pgs.

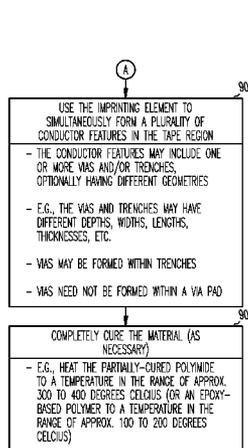
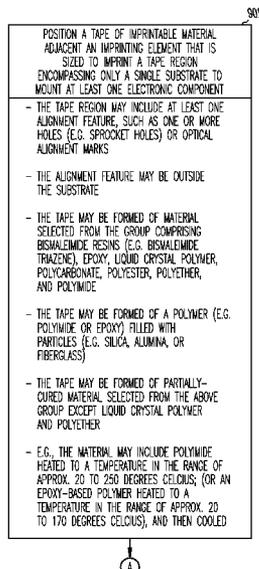
(Continued)

*Primary Examiner*—C. J Arbes  
(74) *Attorney, Agent, or Firm*—Schwegman, Lundberg & Woessner, P.A.

(57) **ABSTRACT**

A package includes at least one electronic component mounted on a substrate formed through imprinting. In an embodiment, the substrate may comprise conductive traces, vias, and patterns of lands on one or more layers. Conductor features of different geometries may be formed by imprinting them simultaneously on one or both surfaces of an imprintable tape. Fabrication apparatus and methods, as well as application of the imprinted package to an electronic assembly, are also described.

**29 Claims, 8 Drawing Sheets**



U.S. PATENT DOCUMENTS

5,830,563	A	11/1998	Shimoto et al.
5,928,767	A	7/1999	Gebhardt et al.
6,005,198	A	12/1999	Gregoire
6,080,656	A	6/2000	Shih et al.
6,127,196	A	10/2000	Butera et al.
6,140,234	A	10/2000	Uzoh et al.
6,156,221	A	12/2000	Lauffer et al.
6,156,870	A	12/2000	Morita et al.
6,254,972	B1	7/2001	Farquhar et al.
6,410,418	B1	6/2002	Yang
6,422,528	B1	7/2002	Domeier et al.
6,482,742	B1	11/2005	Chou
6,511,912	B1	1/2003	Chopra et al.
6,783,652	B2*	8/2004	Iijima et al. .... 205/125
6,815,709	B2	11/2004	Clothier et al.
6,930,256	B1	8/2005	Huemoeller et al.
6,974,775	B2	12/2005	Keser et al.
7,371,975	B2	5/2008	Dory et al.
2003/0135998	A1	7/2003	Walz et al.
2004/0118594	A1	6/2004	Dory et al.
2004/0124533	A1	7/2004	Keser et al.

FOREIGN PATENT DOCUMENTS

GB	2212332	7/1989
JP	11-186698	7/1999
JP	00-124581	4/2000
WO	WO-01/50825	A1 7/2001

OTHER PUBLICATIONS

"U.S. Appl. No. 10/323,165 Non-Final Office Action Mailed On Oct. 7, 2008", 12 pgs.  
 "U.S. Appl. No. 10/323,165 Final Office Action mailed Mar. 17, 2009", 11 pgs.  
 "U.S. Appl. No. 10/335,187 Final Office Action mailed Oct. 8, 2008", 9 pgs.  
 "U.S. Appl. No. 10/323,165 Final office action mailed Jun. 5, 2007", 9 pgs.  
 "U.S. Appl. No. 10/323,165 Final office action mailed Jun. 12, 2006", 9 pgs.  
 "Method to Control the Geometry and Vertical Profile of Via Holes in Substrate Materials", *IBM Technical Disclosure Bulletin*, 35, (Oct. 1, 1992),211-216.  
 "U.S. Appl. No. 10/323,165 Non-final office action mailed Jan. 6, 2006", 11 pgs.  
 "U.S. Appl. No. 10/323,165 Non-final office action mailed Jan. 18, 2007", 7 pgs.  
 "U.S. Appl. No. 10/323,165 Response filed Mar. 16, 2007 to non-final office action mailed Jan. 18, 2007", 12 pgs.  
 "U.S. Appl. No. 10/323,165 Response filed Apr. 6, 2006 to non-final office action mailed Jan. 6, 2006", 15 pgs.  
 "U.S. Appl. No. 10/322,902 Final Office Action mailed Nov. 22, 2005", 11 pgs.

"U.S. Appl. No. 10/322,902 Non-Final Office Action mailed Mar. 25, 2005", 13 pgs.  
 "U.S. Appl. No. 10/322,902 Non-Final Office Action mailed Jun. 28, 2006", 16 pgs.  
 "U.S. Appl. No. 10/322,902 Notice of Allowance mailed Jun. 11, 2007", 9 pgs.  
 "U.S. Appl. No. 10/322,902 Response filed Apr. 24, 2006 in response to Final Office Action mailed Nov. 22, 2005", 9 pgs.  
 "U.S. Appl. No. 10/322,902 Response filed Sep. 26, 2005 filed in response to Non-Final Office Action mailed Mar. 25, 2005", 13 pgs.  
 "U.S. Appl. No. 10/322,902 Response filed Oct. 12, 2006 in response to Non-Final Office Action mailed Jun. 28, 2006", 10 pgs.  
 "U.S. Appl. No. 10/323,165 Response filed Aug. 6, 2007 in response to Final Office Action mailed Jun. 5, 2007", 12 pgs.  
 "U.S. Appl. No. 10/323,165 Response filed Oct. 12, 2006 in response to Final Office Action mailed Jun. 12, 2006", 12 pgs.  
 "U.S. Appl. No. 10/335,187 Final Office Action mailed Mar. 9, 2005", 9 pgs.  
 "U.S. Appl. No. 10/335,187 Non-Final Office Action mailed Sep. 15, 2004", 9 pgs.  
 "U.S. Appl. No. 10/335,187 Response filed Jan. 17, 2006 in response to Non-Final Office Action mailed Sep. 15, 2005", 14 pgs.  
 "U.S. Appl. No. 10/335,187 Response filed Jun. 9, 2005 in response to Final Office Action mailed Mar. 9, 2005", 14 pgs.  
 "U.S. Appl. No. 10/335,187 Final Office Action mailed Feb. 3, 2004", 9 pgs.  
 "U.S. Appl. No. 10/335,187 Final Office Action mailed Mar. 23, 2006", 9 pgs.  
 "U.S. Appl. No. 10/335,187 Non-Final Office Action mailed Sep. 15, 2005", 8 pgs.  
 "U.S. Appl. No. 10/335,187 Non-Final Office Action mailed Sep. 16, 2003", 7 pgs.  
 "U.S. Appl. No. 10/335,187 Response filed May 3, 2004 in response to Final Office Action mailed Feb. 3, 2004", 12 pgs.  
 "U.S. Appl. No. 10/335,187 Response filed Nov. 17, 2003 in response to Non-Final Office Action mailed Sep. 16, 2003", 12 pgs.  
 "U.S. Appl. No. 10/335,187 Response filed Dec. 15, 2004 in response to Non-Final Office Action mailed Sep. 15, 2004", 18 pgs.  
 "U.S. Appl. No. 10/335,196 Non-Final Office Action mailed May 28, 2004", 14 pgs.  
 "U.S. Appl. No. 10/335,196 Notice of Allowance mailed Mar. 2, 2005", 8 pgs.  
 "U.S. Appl. No. 10/335,196 Notice of Allowance mailed Jun. 21, 2005", 10 pgs.  
 "U.S. Appl. No. 10/335,196 Response filed Nov. 29, 2004 filed in response to Non-Final Office Action mailed May 28, 2004", 11 pgs.  
 Tormen, M., et al., "Thermocurable Polymers as Resists for Imprint Lithography", *Electronics Letters*, 36, (May 25, 2000),983-984.  
 "U.S. Appl. No. 10/323,165 Response filed Jul. 1, 2008 to Final Office Action mailed Apr. 14, 2008", 11 pgs.  
 "U.S. Appl. No. 10/335,187 Response filed Jun. 27, 2008 to Non-Final Office Action mailed Mar. 27, 2008", 13 pgs.

\* cited by examiner

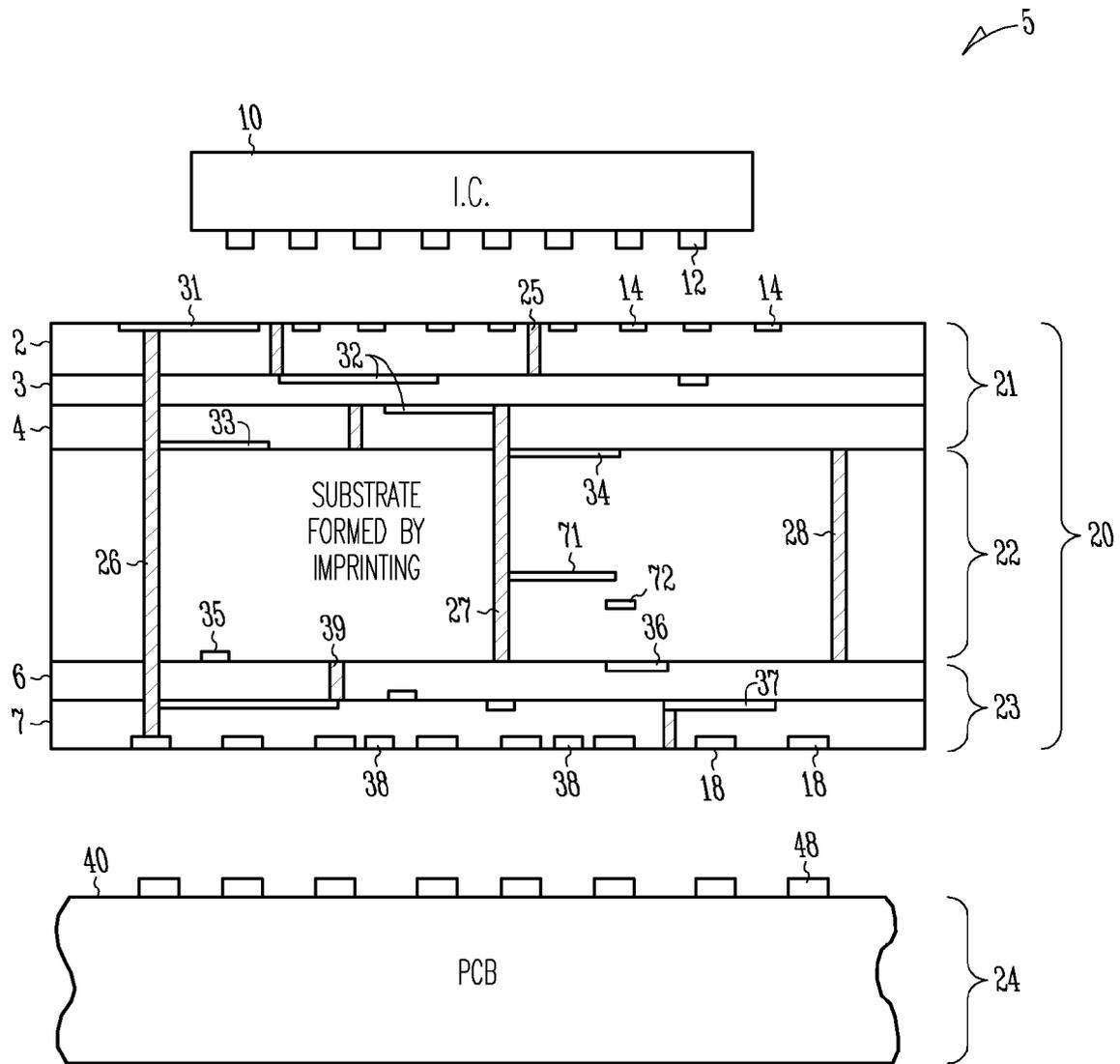
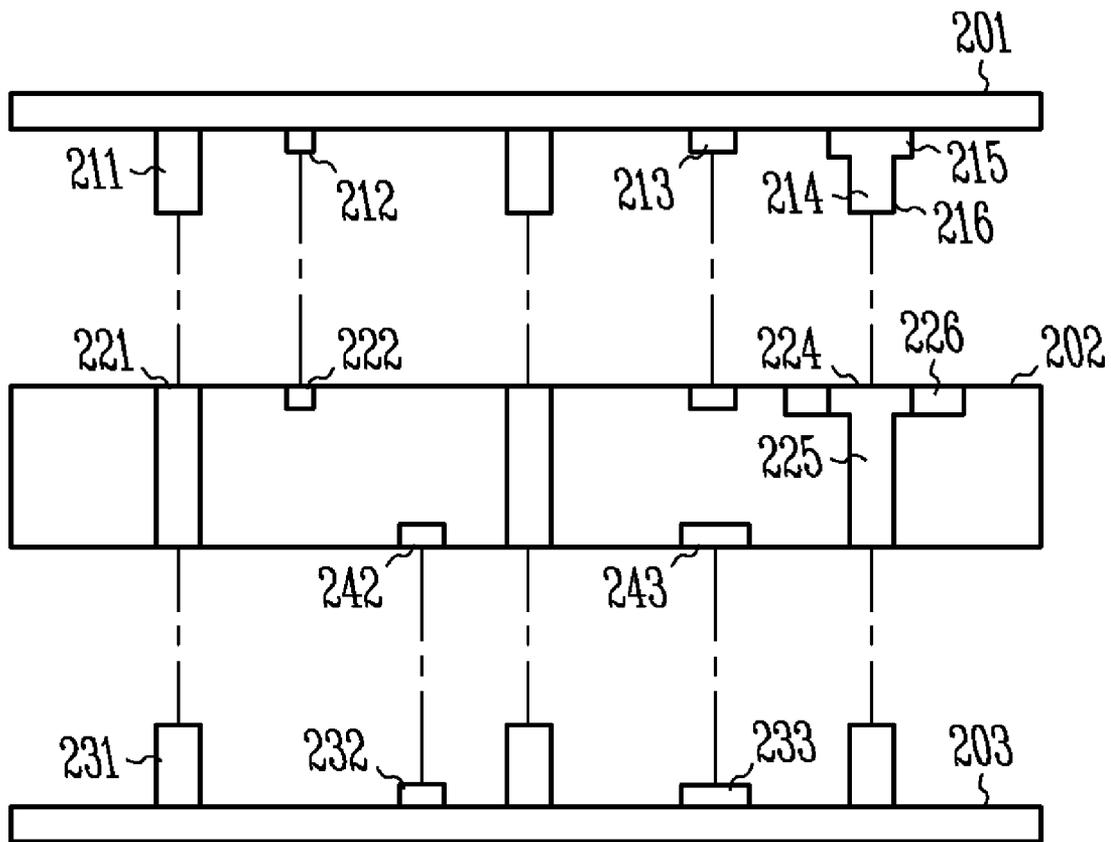
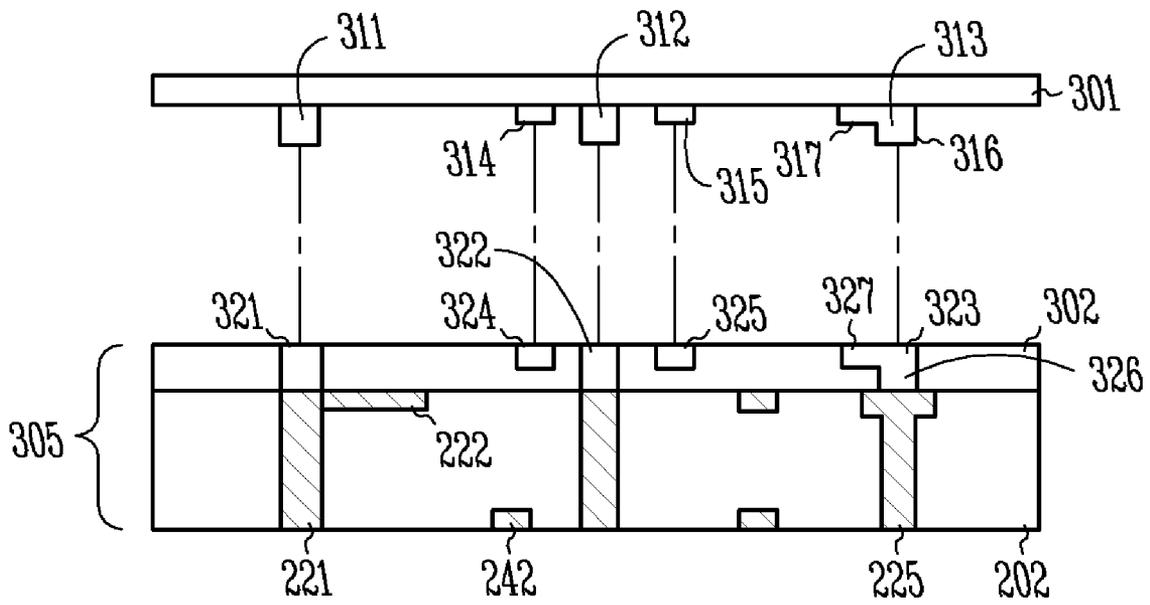


Fig. 1



*Fig. 2*



*Fig. 3*

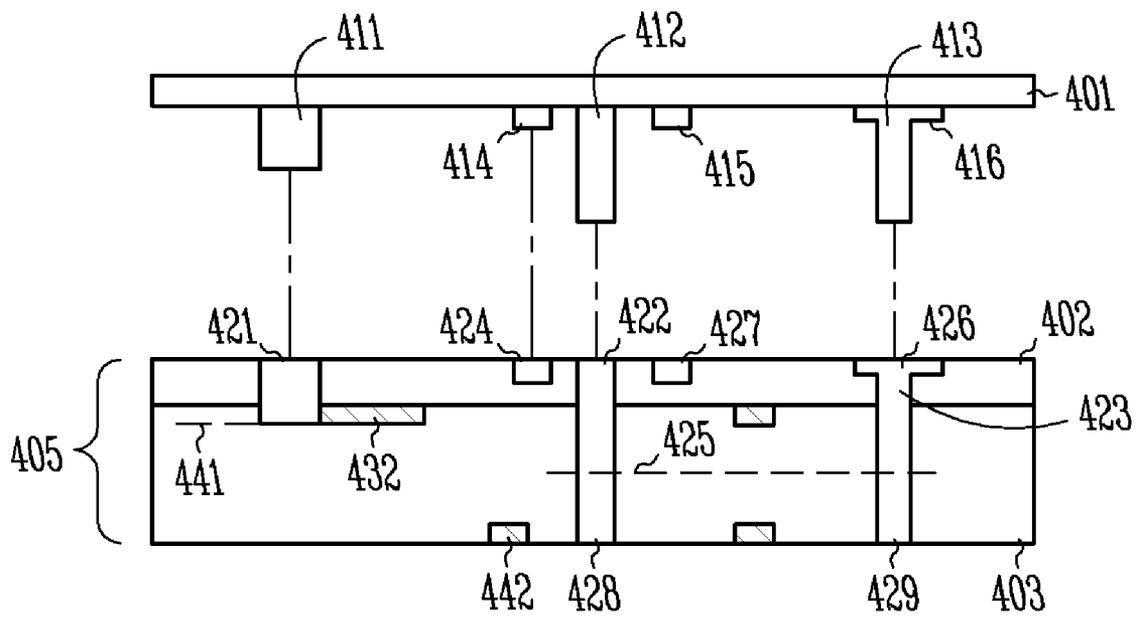
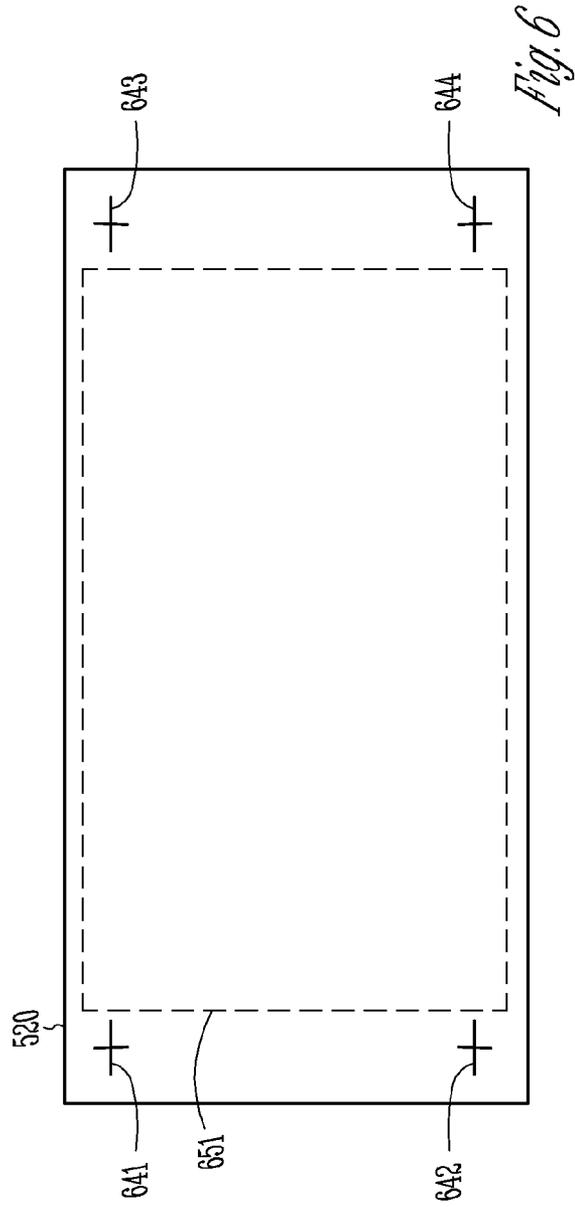
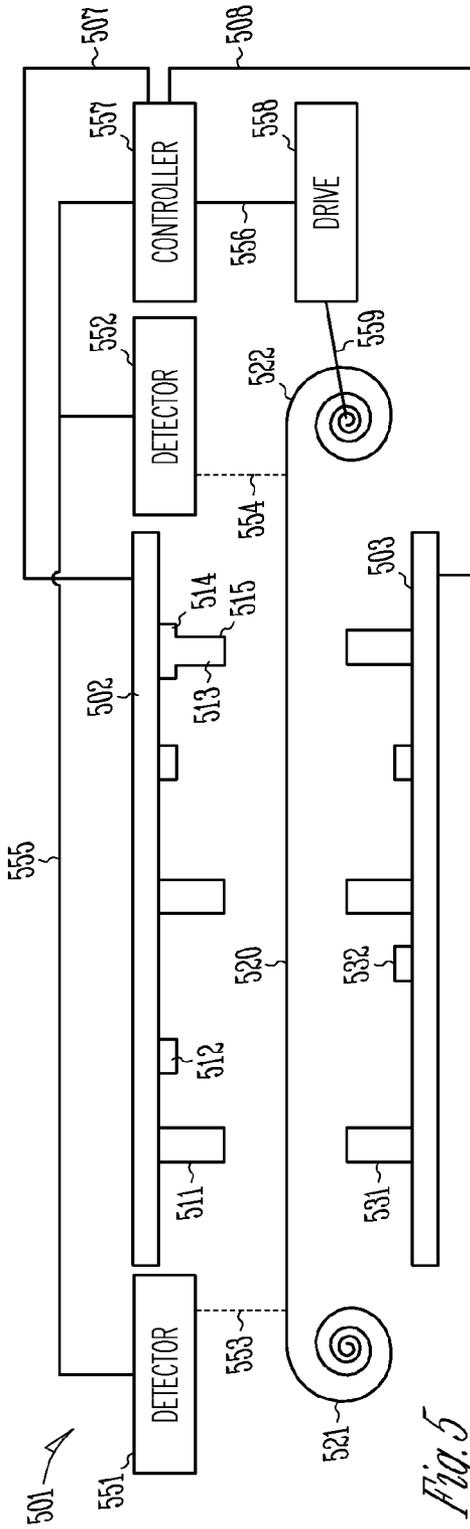
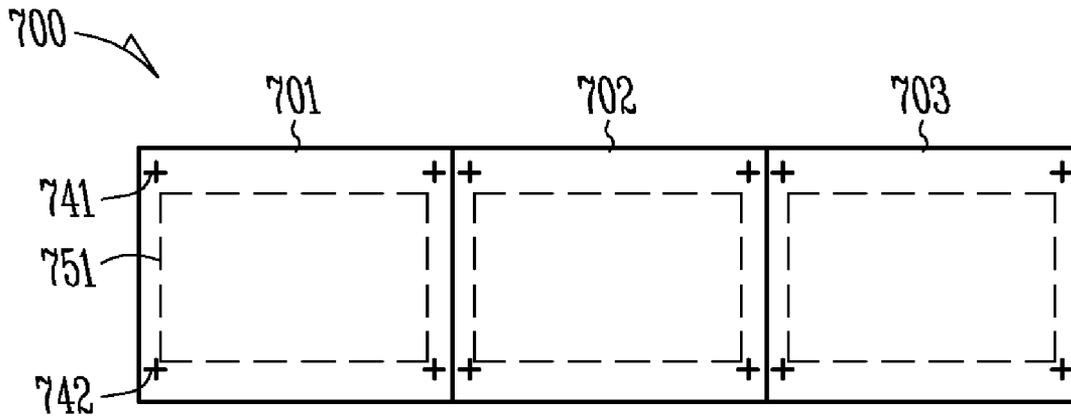
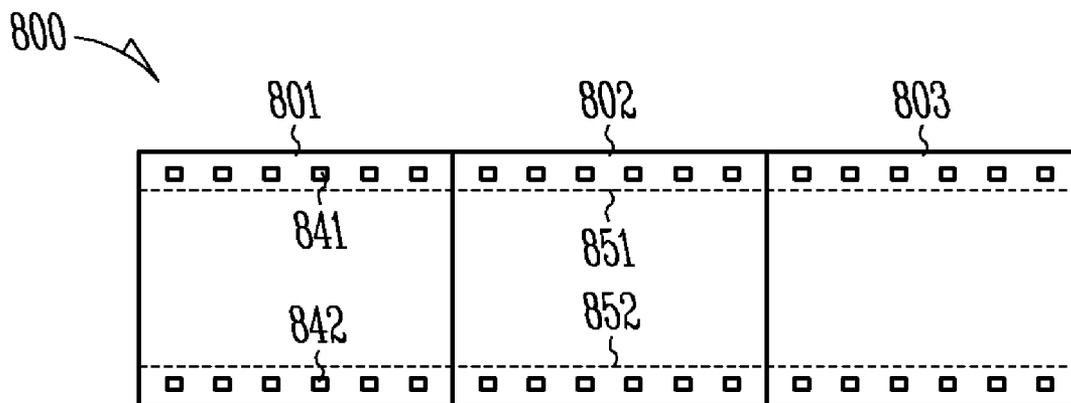


Fig. 4

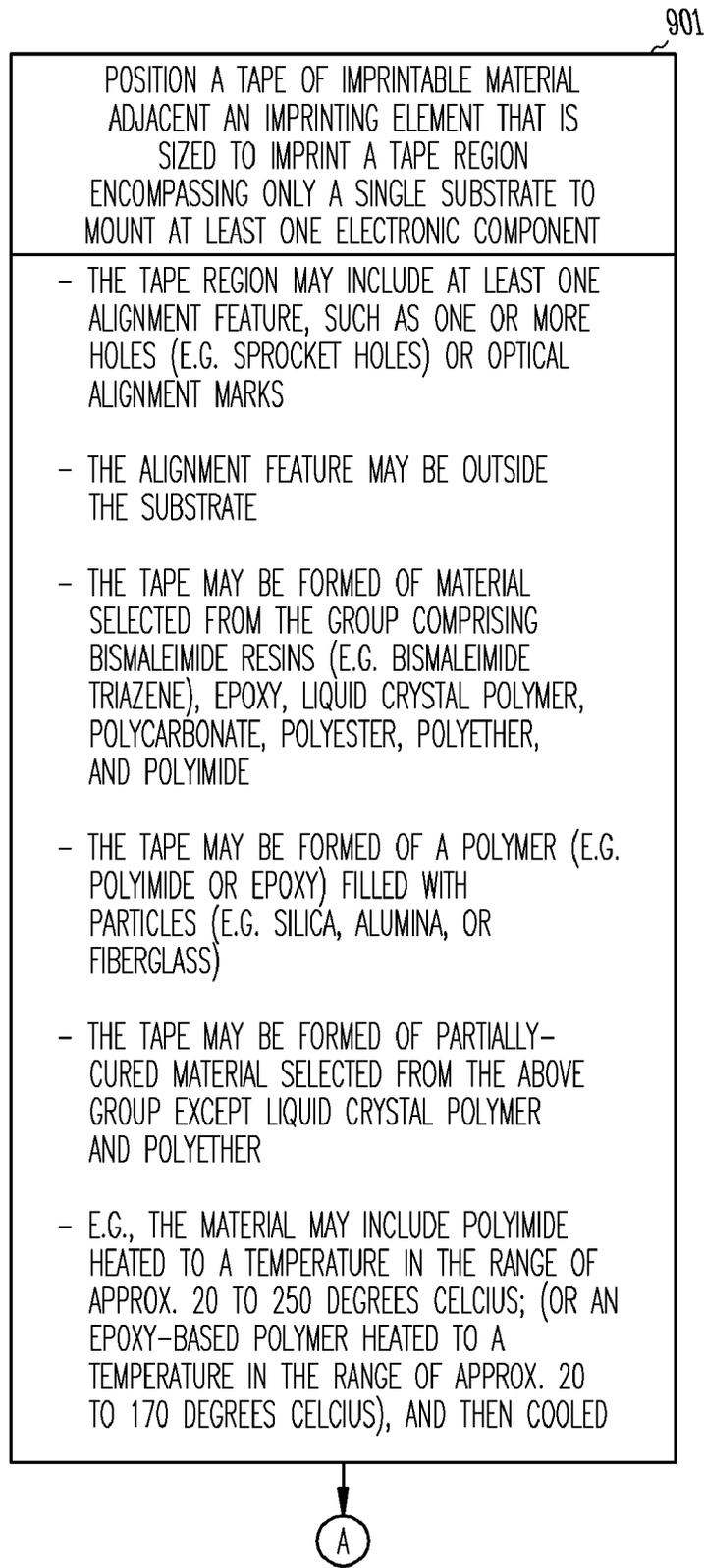


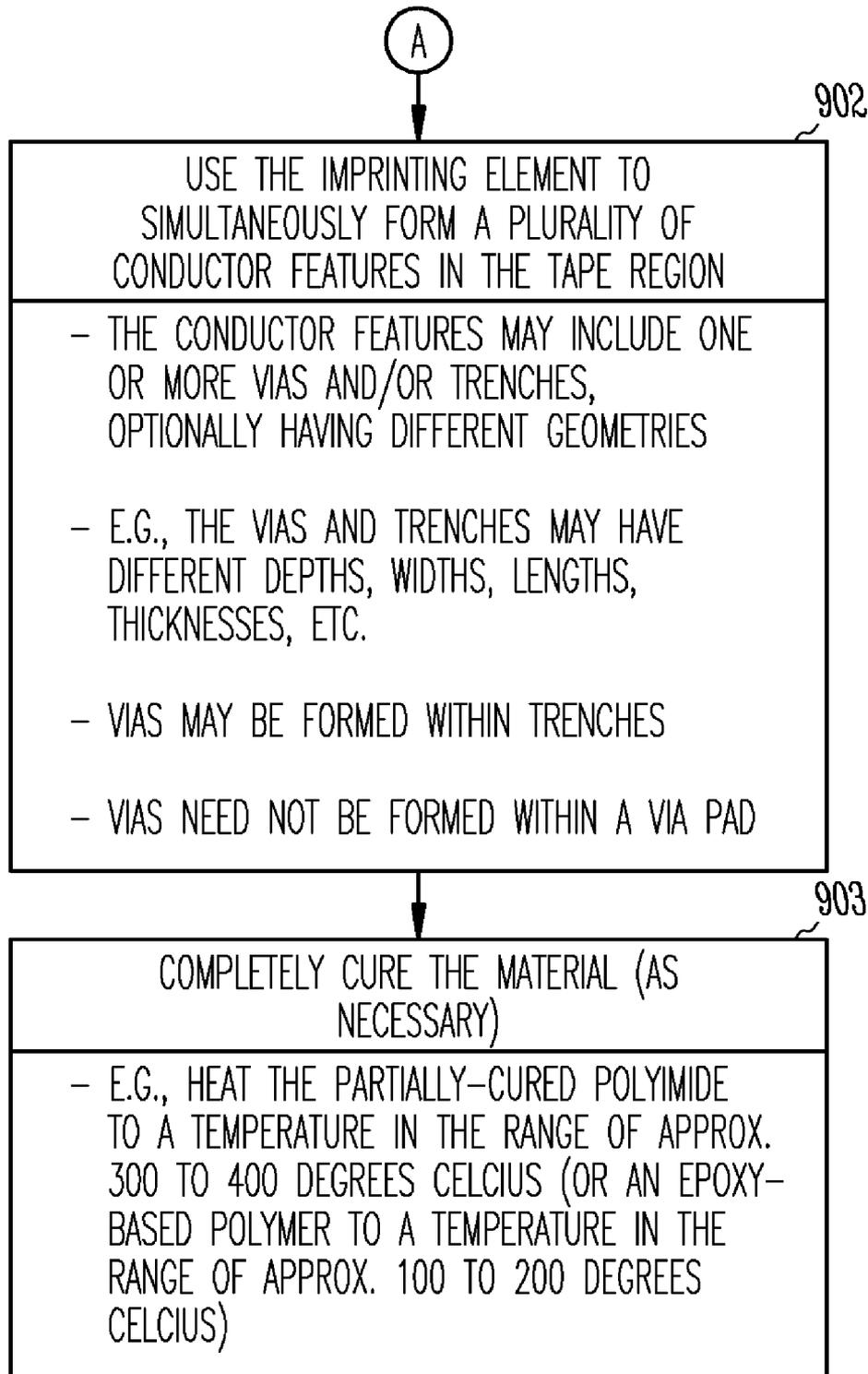


*Fig. 7*



*Fig. 8*

*Fig. 9A*

*Fig. 9B*

**SUBSTRATE-IMPRINTING METHODS**

## RELATED APPLICATIONS

The present application is a divisional of U.S. patent application Ser. No. 10/322,902, filed on Dec. 18, 2002, now issued as U.S. Pat. No. 7,371,975, which is incorporated herein by reference.

The present application is related to the following applications, which are assigned to the same assignee as the present application:

(1) Ser. No. 10/323,165, entitled "Methods for Manufacturing Imprinted Substrates"; and

(2) Ser. No. 10/335,187, entitled "Methods for Performing Substrate Imprinting using Thermoset Resin Varnishes".

## TECHNICAL FIELD

The subject matter relates generally to electronics packaging. More particularly, the subject matter relates to an electronic package that includes an electronic component packaged on a substrate formed through imprinting, and to manufacturing apparatus and methods related thereto.

## BACKGROUND INFORMATION

Integrated circuits (ICs) have typically been assembled into electronic packages by physically and electrically coupling them to a substrate made of organic or ceramic material. One or more such IC packages can be physically and electrically coupled to a secondary substrate such as a printed circuit board (PCB) or motherboard to form an "electronic assembly". The "electronic assembly" can be part of an "electronic system". An "electronic system" is broadly defined herein as any product comprising an "electronic assembly". Examples of electronic systems include computers (e.g., desktop, laptop, hand-held, server, etc.), wireless communications devices (e.g., cellular phones, cordless phones, pagers, etc.), computer-related peripherals (e.g., printers, scanners, monitors, etc.), entertainment devices (e.g., televisions, radios, stereos, tape and compact disc players, video cassette recorders, MP3 (Motion Picture Experts Group, Audio Layer 3) players, etc.), and the like.

In the field of electronic systems there is an incessant competitive pressure among manufacturers to drive the performance of their equipment up while driving down production costs. This is particularly true regarding the packaging of ICs, where each new generation of packaging must provide increased performance while generally being smaller or more compact in size. As market forces drive equipment manufacturers to produce electronic systems with increased performance and decreased size, IC packaging accordingly also needs to support these requirements.

In addition, manufacturers of high-end IC packages, such as processors, are experiencing increasing demand for IC packages mounted in thin, light-weight, and/or resilient packaging, because such packaging is useful for many applications. For example, hand-held electronic systems, such as cellular telephones, palm-top computers, personal digital assistants, calculators, MP3 players, watches, hearing aids, and similar equipment typically require ICs in thin, light-weight, and/or flexible packages.

An IC substrate may comprise a number of layers. Each layer may include a pattern of metal interconnect lines (referred to herein as "traces") on one or both surfaces. Each layer may also include vias to couple traces or other conductive structure on opposite surfaces of the layer.

An IC substrate typically includes one or more electronic components mounted on one or more surfaces of the substrate. The electronic component or components are functionally connected to other elements of an electronic system through a hierarchy of electrically conductive paths that include the substrate traces and vias. The substrate traces and vias typically carry signals that are transmitted between the electronic components, such as ICs, of the system. Some ICs have a relatively large number of input/output (I/O) terminals (also called "lands" or "pads"), as well as a large number of power and ground terminals.

Surface mount technology (SMT) is a widely known technique for coupling ICs to a substrate. In addition to using SMT to couple an individual IC die to a substrate, it is also well known to use SMT to couple an IC package to a substrate such as a printed circuit board (PCB) or motherboard, using solder bumps, for example.

The formation of conductor features, such as traces and vias, in a substrate typically requires a sequence of complex, time-consuming, and expensive operations that offer ample opportunities for error. For example, forming traces on a single surface of a substrate layer typically requires surface preparation, metallizing, masking, etching, cleaning, and inspecting. Forming vias typically requires drilling, using a laser or mechanical drill. Each process stage requires careful handling and alignment to maintain the geometric integrity of the myriad of traces, vias, and other features. To allow for alignment tolerances, feature sizes and relationships often must be kept relatively large, thus hindering significant reductions in feature density. For example, to provide sufficient tolerance for drilling vias, via pads are typically provided, and these consume significant "real estate".

Fabrication of a typical multi-layer substrate requires that a large number of process operations be performed. In a known example of a multi-layer substrate, a core layer has vias (also referred to herein as "plated through holes" or "PTHs") and traces. Traces may be formed on one or both surfaces of the core layer. One or more build-up layers, each with traces on one or more surfaces, and typically with PTHs, are formed. The features of the build-up layers can be formed while these layers are separate from the core layer, and the build-up layers may then be subsequently added to the core layer. Alternatively, some features of the build-up layers may be formed after such layers have been added to the core layer.

For the reasons stated above, and for other reasons stated below which will become apparent to those skilled in the art upon reading and understanding the present specification, there is a significant need in the art for methods of electronics packaging, and corresponding substrate fabrication apparatus, that minimize the complexity, time, and cost of fabricating substrates.

## BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 illustrates a cross-sectional representation of an electronic assembly incorporating a substrate that is formed by imprinting, in accordance with an embodiment of the inventive subject matter;

FIG. 2 illustrates a cross-sectional representation of a substrate formed by imprinting, and corresponding upper and lower imprinting elements, in accordance with an embodiment of the inventive subject matter;

FIG. 3 illustrates a cross-sectional representation of a substrate formed by imprinting, and a corresponding imprinting element having relatively short imprinting dies, in accordance with an embodiment of the inventive subject matter;

FIG. 4 illustrates a cross-sectional representation of a substrate formed by imprinting, and a corresponding imprinting element having relatively long imprinting dies, in accordance with an embodiment of the inventive subject matter;

FIG. 5 illustrates a block diagram of a substrate-imprinting apparatus, including a cross-sectional representation of upper and lower imprinting elements, and an imprintable tape, in accordance with an embodiment of the inventive subject matter;

FIG. 6 illustrates a top view of a portion of the imprintable tape shown in FIG. 5 having a pattern of alignment marks thereon, in accordance with an embodiment of the inventive subject matter;

FIG. 7 illustrates a top view of a portion of imprintable tape having a pattern of alignment marks thereon, in accordance with an embodiment of the inventive subject matter;

FIG. 8 illustrates a top view of a portion of imprintable tape having a pattern of alignment holes thereon, in accordance with an embodiment of the inventive subject matter; and

FIGS. 9A and 9B together form a flow diagram illustrating a method of fabricating an imprinted substrate, using an imprintable tape, to mount an electronic component, in accordance with one or more embodiments of the inventive subject matter.

#### DETAILED DESCRIPTION

In the following detailed description of embodiments of the inventive subject matter, reference is made to the accompanying drawings that form a part hereof, and in which is shown by way of illustration specific preferred embodiments in which the subject matter may be practiced. These embodiments are described in sufficient detail to enable those skilled in the art to practice them, and it is to be understood that other embodiments may be utilized and that mechanical, chemical, structural, electrical, and procedural changes may be made without departing from the spirit and scope of the present subject matter. The following detailed description is, therefore, not to be taken in a limiting sense, and the scope of embodiments of the present inventive subject matter is defined only by the appended claims.

FIG. 1 illustrates a cross-sectional representation of an electronic assembly 5 incorporating a substrate 20 that is formed by imprinting, in accordance with an embodiment of the inventive subject matter.

“Imprint”, as used herein, means to form features in a material by forcing a tool against and/or into the material. Imprinting includes stamping, embossing, impressing, extruding, and like processes.

Electronic assembly 5 includes at least one integrated circuit (IC) 10 or other type of active or passive electronic component having a plurality of conductive mounting pads 12. The electronic component may be in either packaged or unpackaged form, as appropriate to the type of substrate 20. The IC 10 (or other type of electronic component) may be of any type, including a microprocessor, a microcontroller, a graphics processor, a digital signal processor (DSP), or any other type of processor or processing circuit. Other types of electronic components that may be included in electronic assembly 5 are a custom circuit, an application-specific integrated circuit (ASIC), or the like, such as, for example, one or more circuits (such as a communications circuit) for use in wireless devices like cellular telephones, pagers, computers, two-way radios, and similar electronic systems. Electronic assembly 5 may form part of an electronic system (as defined in the Background section above).

IC 10 is physically and electrically coupled to substrate 20. In an exemplary embodiment, IC pads 12 are coupled to corresponding lands 14 on the upper surface of upper build-up section 21 through a suitable attachment mechanism such as solder balls or bumps (not shown).

“Suitable”, as used herein, means having characteristics that are sufficient to produce the desired result(s). Suitability for the intended purpose can be determined by one of ordinary skill in the art using only routine experimentation.

Electronic assembly 5 may include an additional substrate, such as a printed circuit board (PCB) 24 (or interposer), below substrate 20. Substrate 20 may be physically and electrically coupled to PCB 24. In an exemplary embodiment, substrate pads 18 are coupled to corresponding lands 48 on the upper surface 40 of PCB 24 through a suitable attachment mechanism such as solder (not shown). PCB 24 can optionally have lands (not shown) on its lower surface for attachment to an additional substrate or other packaging structure in the packaging hierarchy.

In the example shown in FIG. 1, the substrate 20 comprises a core layer 22, an upper build-up section 21 of one or more layers, and a lower build-up section 23 of one or more layers. One of ordinary skill in the art will appreciate that many alternative embodiments are possible, including but not limited to a substrate comprising only a core layer; a substrate comprising a core with two or more upper and/or lower build-up layers; a substrate comprising a core with only upper build-up layer(s); a substrate comprising a core with only lower build-up layer(s); and so forth.

The various constituent layers of substrate 20 can be formed of any suitable material or combination of materials, such as organic or ceramic materials. In various exemplary embodiments, the substrate starting materials may comprise partially-cured organic materials, chemically or thermally softened organic materials, and green ceramic materials. Any other suitable type of material may be used, provided that it can receive an imprint and can retain such for a period of time long enough to permit the imprinted features, such as vias and trenches, to be formed into conductor features, as for example by inserting conductive material into the imprinted features.

“Conductor feature”, as used herein, means any type of conducting element associated with a substrate, including vias (e.g. blind vias, through vias, etc.), conductors (e.g. surface traces, internal traces, conductive planes, etc.), mounting terminals (e.g. pads, lands, etc.), and the like.

“Via”, as used herein, means any type of conducting element to provide a conductive path between different depths in a substrate. For example, a via can connect conductive elements on opposite surfaces of a substrate, and a via can connect conductive elements at different internal layers within a substrate.

“Trench”, as used herein, means any type of conducting element to provide a conductive path at a relatively constant depth in a substrate. “Trench” includes traces, ground planes, and terminals. For example, a trace may connect conductive elements on one surface of a substrate. A ground plane may provide a conductive path at a relatively constant depth within a substrate. Terminals may provide conductive paths on one surface of a substrate.

Core layer 22, in the example shown in FIG. 1, comprises conductor features in the form of vias 26-28. Core layer 22 also comprises conductor features in the form of one or more trenches 34 in its upper surface, one or more trenches 35 in its lower surface, and one or more internal trenches (e.g. traces 71 and 72). Some or all of the conductor features may be formed through an imprinting process, as will be explained in greater detail below.

Core layer **22** may be formed in various ways. For example, core layer **22** may be formed as a single layer of material. Alternatively, core layer **22** may comprise multiple layers of material. In the example shown in FIG. 1, core layer **22** comprises multiple layers, and internal traces **71** and **72** are formed in the vicinity of the boundaries between individual layers. The boundaries between the multiple layers making up core layer **22** are not shown in FIG. 1. Internal traces **71** and **72** may be formed in any suitable manner, including a manner that is similar to or identical to that used to form trenches in upper build-up section **21** and lower build-up section **23**, as will be explained in greater detail below.

Upper build-up section **21**, in the example shown in FIG. 1, comprises three build-up layers **2-4**. Upper build-up section **21** further comprises conductor features in the form of one or more vias **25** and **26**, one or more trenches (e.g. trace **31** and lands **14**) in the upper surface of layer **2**, and one or more trenches **33** in the lower surface of layer **4**. Upper build-up section **21** may further comprise internal trenches **32**, which may be formed in the internal upper and/or lower surfaces of layers **2-4**, such as in the lower surface of layer **2**, the upper or lower surfaces of layer **3**, and/or in the upper surface of layer **4**.

Lower build-up section **23**, in the example shown in FIG. 1, comprises two build-up layers **6-7**. Lower build-up section **23** further comprises conductor features in the form of one or more vias **26** and **39**, one or more trenches **36** in the upper surface of layer **6**, and one or more trenches (e.g. traces **38** and pads **18**) in the lower surface of layer **7**. Lower build-up section **23** may further comprise one or more internal trenches **37**, which may be formed in the internal upper and/or lower surfaces of layers **6-7**, such as in the lower surface of layer **6**, and/or in the upper surface of layer **7**.

FIG. 2 illustrates a cross-sectional representation of a substrate **202** formed by imprinting, and corresponding upper and lower imprinting elements **201** and **203**, in accordance with an embodiment of the inventive subject matter. Substrate **202**, as shown in FIG. 2, can be a self-contained substrate, or it can form part of a multi-layer substrate.

Substrate **202** comprises one or more vias, such as vias **221** and **225**. Substrate **202** further comprises one or more trenches, such as trenches **222**, **224**, **242**, and **243**. Trenches **222** and **224** (e.g. traces or lands) are in the upper surface of substrate **202**, while other trenches, such as trenches **242-243**, are in the lower surface of substrate **202**.

Via **225** is formed within trench **224**. In accordance with the present subject matter, vias, such as via **225**, need not be formed within via pads. Via pad **226**, shown in dashed outline, depicts a prior art structure (unnecessary in embodiments of the present inventive subject matter) that is used to assure that vias are drilled within a region of the substrate so that they ultimately make electrical contact with a trace to which the via pad is connected. Via pads, as used in prior art substrate structures, thus provide a fairly wide tolerance with respect to the location of corresponding via holes. A disadvantage of using via pads is the significant amount of real estate they consume on the substrate surface.

In the imprinted substrate **202** depicted in FIG. 2, the trench **224** and the via **225** are formed simultaneously, so there is no need to provide a via pad to assist in registering via **225** with trench **224**. By eliminating the need for via pads, the imprinted substrate **202** can accommodate a higher density of conductor features, such as vias, traces, and mounting terminals.

Also shown in FIG. 2 are an upper imprinting element **201** and a lower imprinting element **203**. Upper and lower

imprinting elements **201** and **203** may be considered imprinting tools. They may also be referred to as stamping tools or micro tools.

Upper imprinting element **201** comprises a plurality of protrusions or dies, such as dies **211-214**. Dies **211-214** may be of different geometries. For example, dies **211-214** may have different widths and depths. Dies **211** and **214** have greater depths than dies **212** and **213**. Dies **211** and **213** have greater widths than die **212**.

Die **214** provides a combination of at least two different geometries. Die **214** includes a relatively wide region **215** at its base, corresponding to trench **224** in the upper surface of substrate **202**. Die **214** further includes a narrower region **216**, corresponding to via **225** in substrate **202**.

Lower imprinting element **203** also comprises a plurality of protrusions or dies, such as dies **231-233**. Dies **231-233** may be of different geometries. For example, dies **231-233** may have different widths and depths. Die **231** has a greater depth than die **232**. Die **233**, to form mounting pad **243**, has a greater width than dies **231** and **232**.

FIG. 3 illustrates a cross-sectional representation of a substrate **305** formed by imprinting, and a corresponding imprinting element **301** having relatively short imprinting dies **311-315**, in accordance with an embodiment of the inventive subject matter. Substrate **305**, as shown in FIG. 3, can be a self-contained substrate, or it form part of a multi-layer substrate.

Substrate **305** comprises an upper layer **302** and a lower layer **202**. In an exemplary embodiment wherein additional build-up layers (not shown) are added below layer **202**, layer **202** could be described as a core layer. For example, in an exemplary embodiment, a number of build-up layers could lie both above and below layer **202**. Layer **202** may include internal traces (not shown) situated between multiple layers (not shown). Such internal traces could be formed in any suitable manner, including a manner that is similar to or identical to that used to form trenches **324-325** in upper layer **302**, as will be explained in greater detail below.

In the example shown in FIG. 3, layer **202** has been previously imprinted in an imprinting operation. After the imprinting operation, a suitable conductive material such as copper was inserted into the conductor features of layer **202**. Thus, vias **221** and **225**, and trenches **222** and **242**, contain conductive material, as represented by cross-hatching.

After having conductive material applied to it, layer **202** was registered with and coupled to layer **302** to form substrate **305**.

Layer **302** comprises a plurality of conductor features that have been formed therein. The conductor features may include vias such as vias **321-323** and trenches such as trenches **324-325**.

Also shown in FIG. 3 is an imprinting element **301**. Imprinting element **301** includes a plurality of dies **311-315**. In the example shown in FIG. 3, the depths of dies **311-313**, used to form corresponding vias **321-323** in layer **302**, are relatively short, and they do not extend beyond the lower surface of layer **302** when imprinting element **301** is pressed against layer **302**.

Die **313** is asymmetrical and is shaped to form a via at or very near the edge of a trench. Die **313** comprises a portion **316** to form via **326**. Die **313** further comprises a portion **317** to form trench **327**. Portion **317** is offset from portion **316**.

FIG. 4 illustrates a cross-sectional representation of a substrate **405** formed by imprinting, and a corresponding imprinting element **401** having relatively long imprinting dies **412-413**, in accordance with an embodiment of the inventive

subject matter. Substrate **405**, as shown in FIG. 4, can be a self-contained substrate, or it form part of a multi-layer substrate.

Substrate **405** comprises an upper layer **402** and a lower layer **403**. In an exemplary embodiment wherein additional build-up layers (not shown) are added below layer **403**, layer **403** could be described as a core layer. For example, in an exemplary embodiment, a number of build-up layers could lie both above and below layer **403**. Layer **402** may include internal traces (not shown) situated between multiple layers (not shown). Such internal traces could be formed in any suitable manner, including a manner that is similar to or identical to that used to form trenches **424** and **427** in upper layer **402**.

In the example shown in FIG. 4, lower layer **403** has been previously imprinted in an imprinting operation. After the imprinting operation, a suitable conductive material such as copper was inserted into the conductor features of layer **403**. Thus, trenches **432** and **442** contain conductive material, as represented by cross-hatching.

After having conductive material applied to it, lower layer **403** was registered with and coupled to upper layer **402**. Lower layer **403**, which had certain conductor features (e.g. trenches **432** and **442**) imprinted in a first imprinting operation (using a different imprinting element than imprinting element **401**), may have other conductor features (e.g. vias **421**, **422**, and **423**) imprinted in a second imprinting operation (using imprinting element **401**).

Also shown in FIG. 4 is an imprinting element **401**. Imprinting element **401** includes a plurality of dies **411-415**. In this example, the depths of dies **412-413** that are used to form corresponding vias **422-423** in layer **402** are relatively long, and they extend beyond the lower surface of layer **402** when imprinting element **401** is pressed against layer **402**. Dies **412** and **413** may extend as far into layer **403** as dashed line **425**.

In the example shown in FIG. 4, upper layer **402** has not been previously imprinted in an imprinting operation. Upper layer **402**, in registration with lower layer **403**, is imprinted simultaneously with lower layer **403**. In such an imprinting operation, various conductor features are formed in upper layer **402**. The conductor features may include via **421** (which also extends partly into lower layer **403**), vias **422-423**, and trenches such as trenches **424** and **427**.

As mentioned above, dies **412-413** are used to form vias **422-423**. Vias **422-423** pass entirely through upper layer **402** and at least partly into lower layer **403**, down to dashed line **425**. In the embodiment shown in FIG. 4, the lower portions **428-429** of vias **422-423** within lower layer **403** are formed by corresponding dies of a lower imprinting element (not shown). Alternatively, the lower portions **428-429** of vias **422-423** could be formed by the use of a different imprinting element **401** having longer dies **412-413**.

Die **411** of imprinting element **401** is relatively short. Die **411** extends entirely through upper layer **402**, forming via **421** therein, and die **411** further extends only to dashed line **441** within lower layer **403**.

Dies **414** and **415** of imprinting element **401** are also relatively short, and they are used to form corresponding trenches **424** and **427** in the upper surface of upper layer **402**.

Die **413** is shaped to form a via within a trench. Die **413** comprises a relatively long portion **413** to form via **423**. Die **413** further comprises a portion **416** to form a corresponding trench **426**.

In addition to the examples shown, many other types of substrates can be formed, including printed circuit board (PCB) substrates having one or more layers.

FIG. 5 illustrates a block diagram of a substrate-imprinting apparatus **501**, including a cross-sectional representation of upper and lower imprinting elements **502** and **503**, and an imprintable film or tape **520**, in accordance with an embodiment of the inventive subject matter.

Substrate-imprinting apparatus **501**, in the example illustrated in FIG. 5, may comprise a tape supply element such as a tape supply roll **521**, and a tape take-up element such as tape take-up roll **522**. One or both of tape supply roll **521** and tape take-up roll **522** are driven by a suitable drive element, such as drive **558**. For example, drive **558** may be coupled to tape take-up roll **522** through a suitable drive shaft **559**, gearing, or other drive mechanism.

Imprintable tape **520**, which is depicted schematically in FIG. 5, is not drawn to scale and is typically much thicker than shown. Its relative thickness, compared with imprinting elements **502** and **503** may be comparable to that of substrate **202** relative to imprinting elements **201** and **203** (FIG. 2). Imprintable tape **520** may comprise one or more layers. The width of imprintable tape **520** may be approximately the same as that of the substrate being fabricated. In other embodiments, the width of imprintable tape **520** may be wider than that of the substrate being fabricated.

Imprintable film or tape **520** may be formed of material selected from the group comprising bismaleimide resin, such as bismaleimide triazene (known in the art as "BMT"), epoxy, liquid crystal polymer, polycarbonate, polyester, polyether, and polyimide. Optionally, the imprintable tape material may be formed of a polymer, such as polyimide or epoxy, to which particles have been added. For example, the particles may comprise silica, alumina, or fiberglass.

Imprinting elements **502** and **503** may be similar to those discussed above in FIGS. 2-4. Imprinting elements **502** and **503** each comprise a plurality of protrusions or dies. The dies can have different geometries, corresponding to the desired geometries of the set of conductor features to be imprinted into imprintable tape **520**. Dies to form vias may have different depths, widths, etc. Likewise, dies to form trenches may have different depths, widths, lengths, etc.

For example, upper imprinting element **502** may comprise a plurality of relatively long dies, such as die **511** and die portion **515** of die **513**. Dies **511** and **515** may form vias, or portions of vias, in imprintable tape **520**.

Upper imprinting element **502** may also comprise a plurality of relatively short dies, such as die **512** and portion **514** of die **513**. Dies **512** and **514** may form trenches (e.g. for traces and/or terminals) in imprintable tape **520**.

Similarly, lower imprinting element **503** may comprise a plurality of dies, such as dies **531** and **532**. Die **531** is relatively long, and it may be circular in cross-section, in order to form a corresponding via or portion thereof in imprintable tape **520**. Die **532** is relatively short, at least in a cross-sectional depiction; however, it may have a relatively lengthy dimension, as viewed into the drawing, in order to form a relatively long trace, for example.

Imprinting elements may be formed of any suitable material. In an embodiment, the imprinting elements are formed of solid nickel or nickel-plated metal. Other materials with the requisite properties, such as hardness, may also be used. Imprinting elements could be fabricated, for example, by the manufacturers of microtools used to make compact discs ("CDs"), once the present subject matter has been reviewed.

Substrate-imprinting apparatus **501** may include a controller **557**. Controller **557** may be coupled to drive **558** through bus **556**. Controller **557** may be coupled to upper imprinting element **502** and to lower imprinting element **503** through busses **507** and **508**, respectively. Controller **557** may be

implemented in any suitable manner, such as through a programmable machine or a fixed-program machine.

Controller 557 may also be coupled to one or more detectors, such as detectors 551 and 552, via bus 555. Detector 552 may detect an alignment feature (e.g. alignment features 641-644, FIG. 6) on imprintable tape 520. Pathway 554 schematically depicts an alignment relationship between an alignment feature on imprintable tape 520 and detector 552. The alignment relationship may be implemented through any suitable alignment mechanism. For example, a relatively narrow light beam originating in detector 552 could be reflected off a reflective area on imprintable tape 520 and detected by an optical receiver within detector 552. Pathway 554 could also represent a magnetic, electrical, mechanical, or other alignment relationship between detector 552 and an alignment feature on imprintable tape 520. For example, pathway 554 could represent a mechanical arm or cog that engages in a hole in imprintable tape 520.

An additional detector, such as detector 551, could also be used to detect an alignment feature on imprintable tape 520 through a corresponding pathway 553. Detectors 551 and 552, and associated pathways 553 and 554, may be of different types and may be located in any suitable place. For example, detectors could be located on the same surface of imprintable tape 520 but on opposite edges; they could be situated on opposite surfaces of imprintable tape 520; etc.

Using input from one or more detectors 551 and 552, controller 557 may adjust the relative positions of the imprintable tape 520, the upper imprinting element 502, and the lower imprinting element 503. Controller 557 may do this by controlling drive 558 and/or by controlling the movement of the upper imprinting element 502 and the lower imprinting element 503 in the X and Y dimensions through suitable control mechanisms (not shown).

When controller 557 determines that everything is properly aligned, controller 557 controls the upper imprinting element 502 and the lower imprinting element 503 in the Z dimension. The upper imprinting element 502 is moved downward into the upper surface of imprintable tape 520, and the lower imprinting element 503 is moved upward into the lower surface of imprintable tape 520.

FIG. 6 illustrates a top view of a portion of the imprintable tape 520 shown in FIG. 5 having a pattern of alignment marks 641-644 thereon, in accordance with an embodiment of the inventive subject matter.

In the embodiment illustrated in FIG. 6, four alignment marks 641-644 are shown. Alignment marks 641-644 are used to align the imprintable tape 520 in various apparatus used to fabricate substrates. Such apparatus may include, but is not necessarily limited to, the substrate-imprinting apparatus 501 of FIG. 5. Other types of fabrication apparatus using alignment marks 641-644 may include apparatus to join substrate layers, to add or remove material and/or features, to inspect, etc.

More or fewer alignment marks could be used. The alignment marks may have a different shape than that shown. Alignment marks of different shapes, sizes, types, etc. could be used concurrently.

In the embodiment shown in FIG. 6, the alignment marks 641-644 are depicted as positioned outside of a conductor region 651 depicted by a dashed outline.

“Conductor region”, as used herein, means an imaginary projection of a region on the substrate, inside of which region all conductor features (as defined earlier) are contained. A “conductor region” is typically substantially square or rectangular, although it need not be limited to such shapes.

In an embodiment, alignment marks 641-644 are positioned outside of conductor region 651 so as not to encroach upon the surface real estate available for conductor features and other substantive elements of the substrate. However, in another embodiment, the alignment marks may be positioned within the conductor region.

In the embodiment illustrated in FIGS. 5 and 6, upper and lower imprinting elements 502 and 503 are sized to imprint in a tape region encompassing only a single substrate segment. By using imprinting elements of reduced size, relative to the surface area of the substrate being imprinted, better control can be achieved in the Z-dimension, that is, the dimension into the substrate material. Both the substrate material and the imprinting element can be flatter, and the imprint depth can be more uniform over the entire surface of the imprinted material, compared to an imprinting system in which a relatively large substrate surface (e.g. comprising a large number of substrate segments side-by-side) is imprinted using an imprinting element having a relatively large surface.

Further, by using imprinting elements and substrate segments that have relatively small surfaces, any required heating and cooling cycles can be carried out more quickly.

Further, because the alignment features are close to the substrate segments, better alignment accuracy can be achieved, resulting in improved yield and reliability.

FIG. 7 illustrates a top view of a portion of imprintable tape 700 having a pattern of alignment marks thereon, in accordance with an embodiment of the inventive subject matter.

Imprintable tape 700 comprises a plurality of tape regions or segments 701-703. Each segment 701-703 represents an individual substrate, or a portion of an individual substrate (e.g. a single-layer portion or a multi-layer portion). With respect to one segment 701, it may comprise one or more alignment marks 741 and 742, and it comprises a conductor region 751 shown in dashed outline. The size and position of the conductor region 751, relative to segment 701, may be varied.

Alignment marks 741 and 742 are depicted in this example as outside conductor region 751; however, in other embodiments the alignment marks may be positioned inside the conductor region 751, or alignment marks may be positioned both inside and outside conductor region 751.

FIG. 8 illustrates a top view of a portion of imprintable tape 800 having a pattern of alignment holes thereon, in accordance with an embodiment of the inventive subject matter.

Imprintable tape 800 comprises a plurality of tape regions or segments 801-803. Each segment 801-803 represents an individual substrate, or a portion of an individual substrate (e.g. a single-layer portion or a multi-layer portion). With respect to one segment 801, it may comprise one or more alignment sprockets or holes 841 and 842, and it comprises a conductor region shown between dashed lines 851 and 852. The size and position of the conductor region, relative to segment 801, may be varied.

Alignment holes 841 and 842 are depicted in this example as outside the conductor region bounded by dashed lines 851 and 852; however, in other embodiments the alignment holes may be positioned inside the conductor region, or alignment holes may be positioned both inside and outside the conductor region.

Alignment holes, such as alignment holes 841 and 842, can be used in conjunction with a suitable transport mechanism (not shown) to facilitate production movement within a high volume manufacturing environment.

FIGS. 9A and 9B together form a flow diagram illustrating a method of fabricating an imprinted substrate, using an

imprintable tape, to mount an electronic component, in accordance with one or more embodiments of the inventive subject matter.

In **901**, a tape of imprintable material is positioned adjacent an imprinting element. The imprinting element is sized to imprint a tape region or segment (such as segment **701**, FIG. 7) that encompasses only a single substrate. The substrate is to mount at least one electronic component.

The tape region may include at least one alignment feature, such as one or more holes (e.g. sprocket holes) or optical alignment marks. Any other suitable type of alignment feature could also be used. The alignment feature may be outside the substrate. For example, the alignment feature may be outside a conductor region (e.g. conductor region **751**, FIG. 7).

The tape region of the substrate may comprise one or more layers. The substrate may be formed of material selected from the group comprising bismaleimide resin such as bismaleimide triazene (known in the art as "BT"), driclad, epoxy, liquid crystal polymer, polycarbonate, polyester, polyether, and polyimide. Optionally, the substrate material may be formed of a polymer, such as polyimide or epoxy, to which particles have been added. For example, the particles may comprise silica, alumina, or fiberglass.

The substrate material may be heated prior to imprinting. As an example, polyether material may be heated to a temperature in the range of approximately 20 to 250 degrees Celsius prior to imprinting.

The substrate may be formed of a partially-cured material selected from the group comprising bismaleimide resin such as bismaleimide triazene ("BT"), epoxy, polycarbonate, polyester, and polyimide. A partially-cured polymer, referred to in the art as a "B-stage polymer", may be used. The material should be sufficiently soft to be malleable and formable, but it should be sufficiently firm to retain features that are subsequently imprinted into it.

As an example, a partially-cured material may include polyimide heated to a temperature in the range of approximately room temperature (e.g., 20 degrees Celsius) to approximately 250 degrees C. As another example, the partially-cured material may include an epoxy-based polymer heated to a temperature in the range of approximately room temperature to approximately 170 degrees C. Heating may be provided by any suitable apparatus, such as infra-red or microwave radiation, heating coils, etc.

In **902**, while maintaining the temperature of the substrate material at the previously described temperature, the imprinting element is used to simultaneously form a plurality of conductor features in the tape region of the substrate. The conductor features may be imprinted in one or both surfaces of the substrate. The set of conductor features may include one or more vias and/or trenches. The conductor features may optionally have different geometries. For example, the conductor features may have different depths, widths, lengths, thicknesses, and the like. Vias may be formed within trenches, e.g. centered within a trench or along the side of a trench. Vias need not be formed within via pads. All conductor features can be formed simultaneously within one or multiple layers.

In **903**, if necessary, the substrate material is completely cured through a suitable process. For example, in the above-mentioned example of polyimide, it may be cured by heating it within the range of approximately 300 to 400 degrees C. In the above-mentioned example of an epoxy-based polymer, it may be cured by heating it within the range of approximately 100 to 200 degrees C. It will be understood by those of ordinary skill in the art that the cure times for such substrate materials may be inversely proportional to the cure temperatures. As one example, a substrate formed from a particular epoxy-based polymer may be cured at 170 C for 30 minutes or at 120 C for 90 minutes.

Although not shown in FIGS. **9A-9B**, at a suitable point in the process, e.g. subsequent to curing the substrate material (if a curing operation is necessary), an electrically conductive material is inserted into the conductor features. The conductive material can be of any suitable type, such as copper, aluminum, silver, etc. The metallization operation may be performed using a suitable technique such as sputtering, plating, etc. A suitable operation to planarize the substrate may be used subsequent to metallization.

A suitable cleaning operation may be performed on the substrate material, if and when required, for example prior to a curing operation, and/or prior to a metallization operation.

Eventually the imprintable tape is separated or "singulated" into individual segments. After singulation, the individual tape substrate segments may be transported throughout the fabrication environment through any suitable apparatus, such as transport carriers or trays, for subsequent fabrication operations, such as combining them with one or more other substrate layers, inspecting them, and possibly other manufacturing operations.

Other types of suitable imprintable material may be used. The operations described above with respect to the methods illustrated in FIGS. **9A-9B** can be performed in a different order from those described herein.

Embodiments of the present inventive subject matter provide for the fabrication of electronic substrates that can be fabricated with relatively less complexity, time, and cost, and with relatively greater density compared with known electronic substrates.

An electronic system that incorporates one or more electronic assemblies that utilize the present subject matter can be produced in configurations having reduced cost and enhanced reliability relative to known structures and fabrication methods, and such systems are therefore more commercially attractive.

As shown herein, the present subject matter can be implemented in a number of different embodiments, including an electronic package substrate, an electronic package, various methods of fabricating a substrate, and a machine to fabricate a substrate. Other embodiments will be readily apparent to those of ordinary skill in the art. The elements, materials, geometries, dimensions, and sequence of operations can all be varied to suit particular packaging requirements.

FIGS. **1** through **8** are merely representational and are not drawn to scale. Certain proportions thereof may be exaggerated, while others may be minimized. FIGS. **1-9** are intended to illustrate various implementations of the subject matter that can be understood and appropriately carried out by those of ordinary skill in the art.

Although specific embodiments have been illustrated and described herein, it will be appreciated by those of ordinary skill in the art that any arrangement that is calculated to achieve the same purpose may be substituted for the specific embodiment shown. This application is intended to cover any adaptations or variations of the present subject matter. Therefore, it is manifestly intended that embodiments of this inventive subject matter be limited only by the claims and the equivalents thereof.

It is emphasized that the Abstract is provided to comply with 37 C.F.R. §1.72(b) requiring an Abstract that will allow the reader to quickly ascertain the nature and gist of the technical disclosure. It is submitted with the understanding that it will not be used to interpret or limit the scope or meaning of the claims.

In the foregoing Detailed Description of Embodiments of the Inventive subject matter, various features are grouped together in a single embodiment for the purpose of streamlining the disclosure. This method of disclosure is not to be interpreted as reflecting an intention that the claimed embodiments of the inventive subject matter require more features

13

than are expressly recited in each claim. Rather, as the following claims reflect, inventive subject matter lies in less than all features of a single disclosed embodiment. Thus the following claims are hereby incorporated into the Detailed Description of Embodiments of the Inventive subject matter, with each claim standing on its own as a separate preferred embodiment.

What is claimed is:

1. A method comprising:  
positioning a tape of imprintable material adjacent an imprinting element, the imprintable material having an upper surface and a lower surface, and the tape comprising a plurality of tape regions;  
using the imprinting element, forming a plurality of conductor features simultaneously in a conductor region of each tape region, each tape region encompassing only a single substrate to mount at least one electronic component on the upper surface;  
wherein the plurality of conductor features include a plurality of vias;  
wherein at least a first one of the vias comprises an upper portion formed by imprinting it from the upper surface;  
wherein the at least first one of the vias further comprises a lower portion formed by imprinting it from the lower surface; and  
singulating the tape into individual tape regions.
2. The method recited in claim 1 wherein, in positioning, the tape region comprises at least one alignment feature.
3. The method recited in claim 2 wherein, in positioning, the at least one alignment feature comprises one or more holes.
4. The method recited in claim 3 wherein, in positioning, the one or more holes are not within the conductor region.
5. The method recited in claim 2 wherein, in positioning, the at least one alignment feature comprises at least one optical alignment mark.
6. The method recited in claim 5 wherein, in positioning, the at least one optical alignment mark is not within the conductor region.
7. The method recited in claim 1 wherein, in forming, the conductor features comprise at least one trench and at least one via formed within the at least one trench.
8. The method recited in claim 1 wherein, in forming, the conductor features comprise a plurality of trenches and vias having different geometries.
9. The method recited in claim 8, wherein selected trenches have different depths.
10. The method recited in claim 8, wherein selected trenches have different widths.
11. The method recited in claim 8, wherein selected vias have different depths.
12. The method recited in claim 8, wherein selected vias have different widths.
13. The method recited in claim 1 wherein, in forming, the conductor features comprise at least two vias, each via being of a different width.
14. The method recited in claim 1 wherein, in forming, the conductor features comprise at least two vias, each via being of a different depth.
15. The method recited in claim 1 wherein, in forming, the conductor features comprise at least one via not formed within a via pad.
16. The method recited in claim 1 wherein, in positioning, the tape is formed of material selected from the group com-

14

prising bismaleimide, driclad, epoxy, liquid crystal polymer, polycarbonate, polyester, polyether, and polyimide.

17. The method recited in claim 1 wherein, in positioning, the tape is formed of partially-cured material selected from the group comprising bismaleimide, epoxy, polycarbonate, polyester, and polyimide.

18. The method recited in claim 17 wherein, in forming, the partially-cured material comprises a filled polymer.

19. The method recited in claim 18 wherein, in forming, the filled polymer comprises material selected from the group consisting of epoxy and polyimide, wherein the selected material comprises a particle filler selected from the group consisting of alumina, fiberglass, and silica.

20. The method recited in claim 17 wherein, in forming, the partially-cured material comprises polyimide heated to a temperature in the range of approximately 20 to 250 degrees Celsius.

21. The method recited in claim 20 and further comprising: completely curing the material;

wherein, in completely curing, the partially-cured material is heated to a temperature in the range of approximately 300 to 400 degrees Celsius.

22. The method recited in claim 17 wherein, in forming, the partially-cured material comprises an epoxy-based polymer heated to a temperature in the range of approximately 20 to 170 degrees Celsius.

23. The method recited in claim 22 and further comprising: completely curing the material;

wherein, in completely curing, the partially-cured material is heated to a temperature in the range of approximately 100 to 200 degrees Celsius.

24. A method comprising:

positioning a tape of imprintable material adjacent an imprinting element, the tape having an upper surface and a lower surface, and the tape comprising a plurality of identical segments;

using the imprinting element, forming a plurality of conductor features simultaneously in a conductor region of each segment, each segment encompassing only a single substrate to mount at least one electronic component on the upper surface;

wherein the plurality of conductor features include a plurality of vias;

wherein at least a first one of the vias comprises an upper portion formed by imprinting it from the upper surface; wherein the at least first one of the vias further comprises a lower portion formed by imprinting it from the lower surface; and

singulating the tape into individual segments.

25. The method recited in claim 24 wherein, in positioning, each segment comprises at least one alignment feature.

26. The method recited in claim 25 wherein, in positioning, the at least one alignment feature comprises one or more holes.

27. The method recited in claim 26 wherein, in positioning, the one or more holes are not within the conductor region.

28. The method recited in claim 25 wherein, in positioning, the at least one alignment feature comprises at least one optical alignment mark.

29. The method recited in claim 28 wherein, in positioning, the at least one optical alignment mark is not within the conductor region.

\* \* \* \* \*